



DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. DSI 9297	REV. A SHEET 1 OF 1
DATE 05.03.15	TITLE CROSSTUBE MODIFICATION KIT		SCALE NTS
A	05.03.15	NEW ISSUE	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D212-664 REV. B

THE FOLLOWING MODIFICATION IS APPROVED BY DART AND IS IN THE
PROCESS OF BEING INCORPORATED INTO

CANADIAN STC: SH01-9 AND FAA STC: SR01298NY

IT IS ACCEPTABLE TO PERFORM THE FOLLOWING MODIFICATION TO INSTALL DART
D212-664-101/-201 OR D412-664-203 CROSSTUBES AT CHG 001 ON THE FOLLOWING BELL/AA
(OR EQUIVALENT) SKIDTUBES (P/N 412-320-123/-124/-129/-130, 205-050-400-105/-106,
205-050-152-059/-060, 412-050-023-101/-102/-105/-106, 412-050-030-101/-102,
AND 412-050-043-101/-102 SKIDTUBES)

THE ASSEMBLED GEAR MUST BE INSTALLED ON THE AIRCRAFT IN ACCORDANCE WITH IIN-D212-664
REV. B AND THE CROSSTUBES MUST BE MAINTAINED IN ACCORDANCE WITH ICA-D212-664 REV. 1.

- 1) INSERT CROSSTUBE(S) INTO SKIDTUBE SADDLE(S).
- 2) PIN THE SADDLE(S) TO THE CROSSTUBE(S) USING THE AN6-35A/-40A BOLTS
- 3) TRANSFER DRILL 3/8" HOLES (4 PLACES) ON THE FWD AND AFT SIDES OF THE SADDLE TO THE CROSSTUBE.
- 4) OPEN HOLES IN CROSSTUBE(S) TO $\phi 0.386 \pm 0.005$.
- 5) REMOVE CROSSTUBE(S) FROM SADDLE(S), DEBURR DRILLED HOLES, TOUCH UP HOLES WITH MIL-P-85582 OR MIL-P-23377 PRIMER.

NOTE: ON EARLY MODEL BELL SKIDTUBES, THE FWD/AFT HOLES IN THE SADDLE(S) WILL ALSO
HAVE TO BE OPENED TO $\phi 0.386$, DEBURRED, AND TOUCHED UP WITH PRIMER AS DESCRIBED IN
STEP 5.

- 6) INSERT CROSSTUBE(S) INTO SKIDTUBE SADDLE(S). ENSURE SADDLE AND CROSSTUBE HOLES
ARE ALIGNED. ATTACH THE CROSSTUBE TO THE SKIDTUBE SADDLE USING 4 AN6-35A/-40A BOLTS
AND 2 AN6-36A/-41A BOLTS AS SHOWN IN FIGURE 1. ENSURE ALL BOLTS ARE FACING INBOARD
OR AFT. ENSURE BOLT THREADS ARE NOT BEARING ON SADDLE SHEET. EXTRA AN960JD616
WASHERS MAY BE REQUIRED UNDER THE NUT TO ENSURE NUT DOES NOT START THREADING BOLT
SHANK. TORQUE NUTS TO 110 IN-LBS.

- 7) APPLY A BEAD OF SEALANT AROUND THE TOP OF THE SADDLE IN ACCORDANCE WITH THE
AIRCRAFT MAINTENANCE MANUAL.

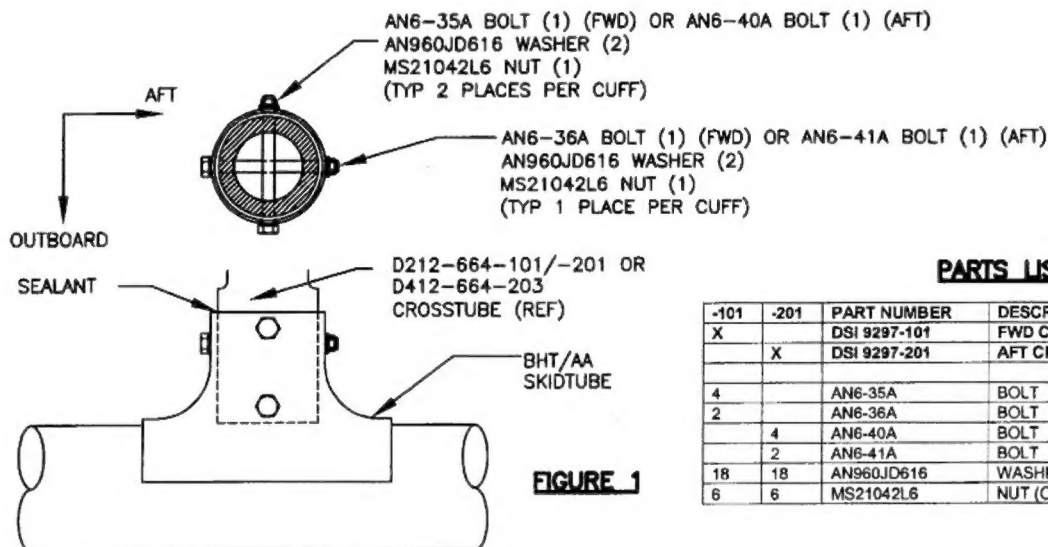


FIGURE 1

PARTS LIST

-101	-201	PART NUMBER	DESCRIPTION
X		DSI 9297-101	FWD CROSSTUBE MODIFICATION KIT
	X	DSI 9297-201	AFT CROSSTUBE MODIFICATION KIT
4		AN6-35A	BOLT
2		AN6-36A	BOLT
	4	AN6-40A	BOLT
	2	AN6-41A	BOLT
18	18	AN960JD616	WASHER
6	6	MS21042L6	NUT (OR MS21042-6)

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